



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3913-041
Job Sheet 186686



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/20/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/7/18	12/7/18	0.00	0.00	Start Up Large Fab-5		<i>C 29/11/18</i>
100	Large Fab	1 pcs	12/7/18	12/7/18	0.00	10.00	Large Fab 1		<i>C 29/11/18</i>
110	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC9		<i>Cpl</i>
120	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		<i>Cpl</i>
125	HandFinish	1 pcs	12/7/18	12/7/18	0.00	0.29	HandFinish2		<i>BEB 18-12-11</i>
130	Powdercoat	1 pcs	12/7/18	12/7/18	0.00	0.93	Powdercoat2		<i>BL 18-12-11</i>
135	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging1		<i>M 18-12-12</i>
140	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC3		<i>M 18-12-12</i>
150	HandFinish	1 pcs	12/7/18	12/7/18	0.00	0.50	HandFinish4		<i>M 18-12-12</i>
160	QC	1 pcs	12/7/18	12/7/18	0.00	0.00	QC5		<i>M 18-12-12</i>
170	Packaging	1 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3-2		<i>DEC 18 2018</i>
180	QC21-SA	1 Ea	12/7/18	12/7/18	0.00	0.00	QC21		<i>DEC 18 2018</i>

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138951 START 3:45 OUT: 3:45 FTNISH: 4:00.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	<i>5 112 888</i>
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5 123 729</i>
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	<i>5 115 269</i>
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	<i>5 124 101</i>
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5 115 925</i>
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	<i>5 116 572</i>
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	<i>5 128 498</i>
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	<i>5 128 079</i>
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	<i>5 115 309</i>
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	<i>2x5 125006/1x5 123991</i>
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	<i>5 115 755</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 pcs (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5118078
 1x5115213/2x5115200
 5125274
 5125500
 5123441
 5093684
 5106552
 F86435
 5076007
 5094692
 5107991
 5118039

Job Allocations

007072

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	66	0
	D3913-1	1	8	0
	D3913-15	1	13	0
	D3913-3	1	9	0
	D3913-7	2	14	0
	D3913-9	1	7	0
	D3916-041	2	12	0
	D3916-5	3	15	0
	D4016-1	3	202	0
	D4017-7	3	44	0
	D4017-9	2	12	0
	D4020-11	2	17	0
	D4021-1	3	42	0
	D4034-041	1	5	0
	D4034-043	1	5	0
	D4672-1	2	28	0
	M304EX0.75-16F	33	2,358	0
	AN3-10A	6	150	0
	D2931	2	912	0
	D4021-5	2	25	0
150-HandFinish	MS20600-AD4W3	2	303	0
	MS21042L3	6	1,662	0
	NAS1149F0332P	12	1,017	0

Part Specifications

Specifications could not be found.

Plex 11/20/18 10:31 AM Dart.lajeunesse.marie

006776

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date: _____		Disposition: _____		MRB (QSI042) Approval _____																	
Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K8A 1K7 CANADA TEL: 519 632-5200 Email: sales@dartaero.com www.dartaero.com Date: 11/29/18 Container No: S133279 Part: D3913-041 Job No: 186686 Serial No/Batch: S133279 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's _____																					